

Work Order ID 74648 -1

Tuesday, October 04, 2011 3:21:50 PM



Page 1

Item ID: D6101-001

Revision ID:

Item Name: Saddle Billet

Start Date: 10/4/2011 Start Qty: 80.00

Required Date: 10/10/2011 Req'd Qty: 80.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 11-10-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D6101

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 15091

a) Description: Aluminum billet

b) 6.00" x 6.250" x 2.00" thick

c) Tolerance on length are +0.030"/-0.000" AE +/-0.008"

d) Grain direction along 6.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

H 11-10-4
80

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

Rec'd 10/18 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

- Picklist Print

Tuesday, October 04, 2011 3:21:58 PM

Page 1

Work Order ID: 74648

Parent Item: D6101-001

Parent Item Name: Saddle Billet




Start Date: 10/4/2011

Required Date: 10/10/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP B: ☐01.05.04 ☐New Issue ☐EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001P  7075-T7351 2X6X6.25		Purchased	No			110	Each	0.0000	1	80			



Rec'd 10/18/11 (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15091

Purchase Order Date 10/4/2011

PO Print Date 10/4/2011

Page Number 1 of 1

Order From :

VC-MET001

METAUX CASTLE

A.M. CASTLE & CO. (CANADA) INC. - BOX B9204 PO BOX 9100

TORONTO, ON M4Y 3A5

CA

Contact Name

Vendor Phone

514 694 9575

Vendor Fax

514 695 3281

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6101-001P	7075-T7351 2X6X6.25	10/7/2011 Yes	80.00 Each	Yours ppd	\$45.1000	\$3,608.00

Special Inst: Aluminum Billet
6.00 x 6.250 x 2.00" thick
Tolerance on length are +0.030"/-0.000" E+/-
0.008"
Grain direction along 6.00" length
Mat: 7075-T7351 (QQ-A-250/12)

2	D6101-003P	7075-T7351 2X6.25X7.875	10/7/2011 Yes	80.00 Each	Yours ppd	\$59.1600	\$4,732.80
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Special Inst: Aluminum Billet
7.875 x 6.250 x 2.00" thick
Tolerance on all dimensions are +0.030"/-
0.000"
Grain direction along 7.875" length
Mat: 7075-T7351 (QQ-A-250/12)

PO Total:

\$8,340.80

Change Nbr:

1

Change Date: 10/4/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



A227289

21X6.25X6

SH3 PRI

R



Castle Metals®

A. M. Castle & Co.

INTERORG TRANSFER
PACKING SLIP

Page 1 of 1

Shipment No:1022881

10/20

Ship From: A. M. Castle & Co. (Canada) Inc. TORONTO 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: A. M. Castle & Co. (Canada) Inc. MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 14-OCT-2011	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier WHITE OAK TRANSPORT LIMITED		BOL No 1022881-2	

Shipment Details			Final Destination Branch - MON				
Order No	Line No	Item No	Description				
1755674	1	752237.MO	2.0000.PL.7075.T7351.ALUMINUM.US1.48.5000.144.5000 CUT 2SIDED TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) X 6 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/12				
Purchase Order No		Part Number	Ordered Qty		Invoice Qty		
15091		YOUR ITEM NUMBER: D6101-001	21.00 PCS		21 PCS		
Details							
Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
98891428		481830A8		21			162.57

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

Name:

KAISER ALUMINUM

FABRICATED PRODUCTS

CERTIFIED TEST REPORT
http://Certs.KaiserAluminum.com

Kaiser Aluminum
Trentwood Works
Spokane, WA 99205-5108
(800) 367-2586

CUSTOMER PO NUMBER: 20985		WORK PACKAGE:	CUSTOMER PART NUMBER: 6857 AMC A97075-60		PRODUCT DESCRIPTION: Sawed Plate
KAISER ORDER NUMBER: 1088788	LINE ITEM: 1	SHIP DATE: 10/27/2009	ALLOY: 7075	CLAD: BARE	TEMPER: T7351
WEIGHT SHIPPED: 25956 LB	QUANTITY: 18 PCS EST.	B/L NUMBER: 2024599	GAUGE: 2.0000 IN	WIDTH: 48.500 IN	LENGTH: 144.500 IN
SHIP TO: CASTLE % CASTLE AEROSPACE 3050 SOUTH HYDRAULIC WICHITA, KS 67216 US			SOLD TO: CAS AERO%AM CASTLE METALS ATTN: BOB OHR %ACCTS PAYABLES 3400 NORTH WOLF ROAD FRANKLIN PARK, IL 60131 US		

Certified Specifications

AMS 4078/RevG AMS-QQ-A-250/12 AMS-STD-2154 ASTM B 209/Rev07 ASTM B 594/Rev06 BAC
5439/RevH BSS 7055/RevA CMMP 025/RevS CSTI 006/RevC DPS 4.713/RevAH GAMPs 9101/RevB
GSS16100/RevG/Amd1 MMS 159/RevN PS 21211/RevK

Test Code: 4297

Test Results:

LOT: 481799A5 CAST: 267 DROP: 92 INGOT: 2

(ASTM E8/B557)

(EN 2002-1)

Tensile: Temper	Dir/#Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
T7351	LT / 02 (Min:Max)	73.9 : 74.2 (510 : 512)	63.0 : 63.2 (434 : 436)	11.5 : 11.8

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS:	40.1 Min	40.4 Max
(MS/M):	23.3 Min	23.4 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.19	1.4	0.06	2.5	0.19	5.6	0.02	0.01	0.01	TOT 0.05

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser) hereby certifies that metal shipped under this order was melted in the United States of America or a qualifying country per DEARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DEARS 252.225 for domestic content. This material has been inspected, tested and found in conformance with the requirements of the applicable specifications as indicated herein. All metal which is solution heat treated complies with AMS 2772. Any warranty is limited to that shown on Kaiser's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of Kaiser Aluminum Fabricated Products, LLC laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law. ISO-9001:2000 certified.

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poy

Plant Serial: 4175120

Kaiser Order Number: 1088788



KAISER ALUMINUM FABRICATED PRODUCTS



CERTIFIED TEST REPORT

<http://Certs.KaiserAluminum.com>

Kaiser Aluminum
Trentwood Works
Spokane, WA 99205-5108
(800) 367-2586

LOT: 481828A2 CAST: 267 DROP: 91 INGOT: 4

(ASTM E8/B557)

(EN 2002-1)

Tensile: Temper	Dir/#Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
T7351	LT / 02 (Min:Max)	74.3 : 74.4 (512 : 513)	62.3 : 63.2 (430 : 436)	11.7 : 12.0

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS:	40.4 Min	40.7 Max
(MS/M):	23.4 Min	23.6 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.11	0.21	1.5	0.07	2.5	0.20	5.6	0.02	0.01	0.01	TOT 0.05

LOT: 481830A8 CAST: 267 DROP: 95 INGOT: 2

(ASTM E8/B557)

(EN 2002-1)

Tensile: Temper	Dir/#Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
T7351	LT / 02 (Min:Max)	75.4 : 75.5 (520 : 521)	64.7 : 65.1 (446 : 449)	11.2 : 11.4

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS:	40.3 Min	40.3 Max
(MS/M):	23.4 Min	23.4 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.22	1.5	0.09	2.5	0.19	5.9	0.02	0.01	0.01	TOT 0.06

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser) hereby certifies that metal shipped under this order was melted in the United States of America or a qualifying country per DFARS 225.072-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content. This material has been inspected, tested and found in conformance with the requirements of the applicable specifications as indicated herein. All metal which is solution heat treated complies with AMS 2772. Any warranty is limited to that shown on Kaiser's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of Kaiser Aluminum Fabricated Products, LLC laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law. ISO-9001:2000 certified.





KAISER ALUMINUM FABRICATED PRODUCTS



CERTIFIED TEST REPORT

<http://Certs.KaiserAluminum.com>

Kaiser Aluminum
Trentwood Works
Spokane, WA 99205-5108
(800) 367-2586

LOT: 481995A9 CAST: 267 DROP: 90 INGOT: 4

(ASTM E8/B557)

(EN 2002-1)

Tensile: Temper	Dir/#Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
T7351	LT / 02 (Min:Max)	75.7 : 76.3 (522 : 526)	65.2 : 65.7 (450 : 453)	11.7 : 11.8

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS:	40.3 Min	40.4 Max
(MS/M):	23.4 Min	23.4 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.19	1.6	0.08	2.5	0.19	6.0	0.02	0.01	0.01	TOT 0.05

LOT: 489687A4 CAST: 267 DROP: 97 INGOT: 1

(ASTM E8/B557)

(EN 2002-1)

Tensile: Temper	Dir/#Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
T7351	LT / 02 (Min:Max)	76.0 : 76.1 (524 : 525)	64.7 : 65.1 (446 : 449)	11.3 : 11.7

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS:	39.4 Min	39.6 Max
(MS/M):	22.9 Min	23.0 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.20	1.5	0.11	2.6	0.19	5.8	0.02	0.01	0.01	TOT 0.04

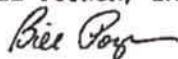
Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
7075	MIN 0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	MAX 0.05
	MAX 0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT 0.15

Aluminum Remainder

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser) hereby certifies that metal shipped under this order was melted in the United States of America or a qualifying country per DFARS 225.072-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content. This material has been inspected, tested and found in conformance with the requirements of the applicable specifications as indicated herein. All metal which is solution heat treated complies with AMS 2772. Any warranty is limited to that shown on Kaiser's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of Kaiser Aluminum Fabricated Products, LLC laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law. ISO-9001:2000 certified.

BILL POYNOR, LABORATORIES SUPERVISOR



Plant Serial: 4175120

Kaiser Order Number: 1088788

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Line Item: 1



**KAISER
ALUMINUM
FABRICATED PRODUCTS****CERTIFIED TEST REPORT**
<http://Certs.KaiserAluminum.com>

Kaiser Aluminum
Trentwood Works
Spokane, WA 99205-5108
(800) 367-2586

Miscellaneous Notes

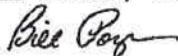
7075-T7351 plate 3.501-4.000 thick, if ultrasonically inspected, meets requirements of CMMP025 per SDR CMMP025-KaiserT-3. 7075-T7351 plate 4.001-5.000 thick, if ultrasonically inspected, meets requirements of CMMP025 per SDR CMMP025-KaiserT-2.

Metal represented by this test report was immersion ultrasonically tested from one side and meets the Class A and Class B requirements of all specifications referenced on this test report.

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser) hereby certifies that metal shipped under this order was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content. This material has been inspected, tested and found in conformance with the requirements of the applicable specifications as indicated herein. All metal which is solution heat treated complies with AMS 2772. Any warranty is limited to that shown on Kaiser's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of Kaiser Aluminum Fabricated Products, LLC laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law. ISO-9001:2000 certified.

BILL POYNOR, LABORATORIES SUPERVISOR



Plant Serial: 4175120

Kaiser Order Number: 1088788

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Line Item: 1



